

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012939**Date Inspected:** 01-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girders (OBG)**Summary of Items Observed:**

Erection Site

Quality Assurance inspector (QA) Michael Foerder was at the American Bridge/Flour (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. OBG Field Splice 2E/3E C-1 FCAW in process
2. OBG Field Splice 3E/4E D Face SAW in process

Field Splice 2E/3E Face C-1

The QA inspector periodically observed the in process Flux Cored Arc Welding (FCAW-G) being performed by ABF welding personnel Mitch Sittinger and Song Tao Huang between Y locations designated 800mm – 2700mm. QC inspector Bernard Docena was noted to be present in order to monitor the progress and ensure the welding was within the established Welding Procedure Specification (WPS) noted as ABF-WPS-D1.5-3042A-1. Prior to initiating the welding the welder and helper increased the root opening by grinding in order to comply with the WPS requirements in areas identified by the QC inspector. The preheat and interpass temperature was verified by the QC and QA inspector to be greater than 65° Celsius (C) and the parameters were verified to be 260 amps, 24.5 volts and a measured travel speed of 290mm/min. The welder is in the process of placing the root and fill passes at this time. The work progressed throughout the morning shift, was not completed by the end of the QA inspectors shift and appeared to be progressing in general conformance with the contract documents.

Field Splice 3E/4E Face D (Inside) In Process SAW

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The QA inspector observed QC inspector Tom Pascaulone performing visual inspections and identifying a significant amount of areas in which slag was entrapped from the welding which took place the previous day. An ABF crew of 3-4 individuals is in the process of removing these locations with approved welding operators Bryce Howell and Chun Fai Tsui being a part of this crew. The QA inspector periodically reviewed this area throughout the shift with no welding performed on this date.

Summary of Conversations:

No significant conversations held on this date for this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Foerder, Mike	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
